

533

DART AEROSPACE LTD	Work Order: - 24072
Description: Custom W/O to correct welding Jig	Part Number: D3379-041
Dwg: D3379 Rev. C page 1	
Ref: N/A	Page 1 of 1

Step	Location	Procedure	By	Date	Qty												
1	DC	Issue Traveler	HT	05.08.15	1												
2	ST	Remove D3379-041 Arm Weldment from store. B22468A <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3379-041</td> <td>Arm Weldment</td> <td>B22470</td> </tr> <tr> <td></td> <td></td> <td></td> <td>B22624</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D3379-041	Arm Weldment	B22470				B22624			
Qty	Part Number	Description	Batch														
1	D3379-041	Arm Weldment	B22470														
			B22624														
3	MFA	Rework the weld by correcting the position of D3379-1 support as per Dwg D3379	HT	06.01.25	1												
4	QC5	Inspect work to Step 3 and jig.	HT	06.01.25	1												
6	FP	Powder Coat Fire Red (Ref. 4.3.5.10) as per QSI 005 4.3															
7	QC3	Inspect Powder Coat															
8	ST	Identify and Stock D3379-041 as per step 2 Return to stock															
9	AC	Charge to project number P601-571/-572 Cost / part: _____															
10	DC	Close W/O Inspect Level 21															

(Note: Attach a copy of Custom W/O to each of the W/O's listed in Step 2 above)

Rev	Date	Change	Revised By	Approved
A	05.08.15	New Issue	KJ/RF	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

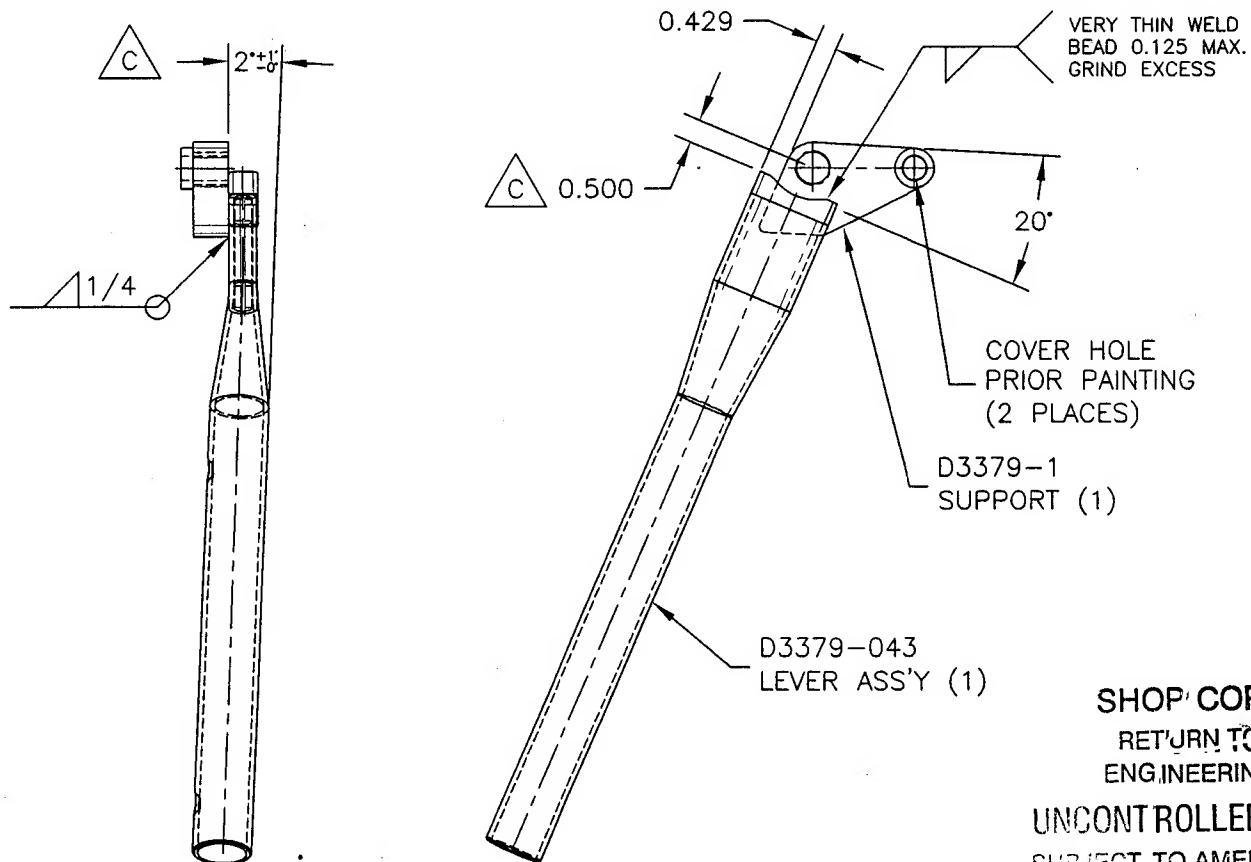
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN 30	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 3	APPROVED JH	DRAWING NO. D3379	REV. C SHEET 1 OF 4
DATE 05.05.27		TITLE ARM WELDMENT	SCALE 1:1
A	04.12.13	NEW ISSUE	
B	05.02.25	RE-DESIGN D3379-5	
C	05.05.27	2" WAS 4"; UPDATE DIMENSIONS	

RELEASED
11/5
05/01/05



D3379-041 ARM WELDMENT

NOTES:

- 1) POSITION PARTS AS PER JIG D3379-041T1
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT FIRE RED (REF 4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 24072

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:50 am

Work Order No : 0024072
Project Name : D3379-041
Project For : WK533
Work Order Type : Main
Main WO Number :
House Part Number : D3379-041
Description : Arm Weldment
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 08-15-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	10.25	100.00		
Production Cost	0.00	164.72	100.00	0.00	164.72
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	164.72	100.00		
Margin	0.000	0.000			
Selling Cost	0.00	164.72			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	(-164.72)

MIS 01/13
u
11-13

Date: Monday, 14/11/2005 8:34:42 AM
 User: Alba Panzuto

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ARM WELDMENT
Job Number :	24072		
Estimate Number :	10450		
P.O. Number :		Part Number :	D3379041
This Issue :	14/11/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3379 REV C
First Issue :	/ /	Project Number :	
Previous Run :	23640	Drawing Revision :	C
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	30/11/2005
Written By :		Qty:	1
Checked & Approved By :		Um:	Each
Comment :	Est A 05.02.03 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3379043	Lever Assembly
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2.0	D33791	Support
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3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
 Assemble and weld using welding Jig DT8764 as per Dwg D3379
 Identify as D3379-041

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
 Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3
 Mask holes

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

Date: Monday, 14/11/2005 8:34:42 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM WELDMENT

Job Number: 24072

Part Number: D3379041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

